



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5124-1
Job Sheet 187578



Part No: D5124-1

Job Qty: 8 pcs

Part Name: Fwd Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 1/18/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV B IPP rev A RQ verified by JLM 14/08/08

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	8 pcs	1/18/19		0.37	12.31	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	8 pcs	1/18/19		0.00	0.00	QC 2 - 1		KA 2019-02-14
							QC 2 - 12		Kt 2019-02-14
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		



Dart Aerospace Ltd.
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CANADA
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Container No: S153825



Part: D5124-1

Job No: 187578

Serial No/Batch: S153825

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/14/19

120 QC 8	8 pcs	1/18/19	0.00	0.00	QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.A 19-02-23
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
130 Packaging 3-1 - Stock - B4B	8 pcs	1/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	LGOSY 148 19-2-28
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	

140 QC 21 - SA				8 pcs	1/18/19	0.00 0.00	Packaging 3 - 36 - B4B	DAS 21 MAR 01 2019
							QC 21 - SA - 21	
							QC 21 - SA - 70	
Part Op 100 - HAAS1-4 (HAAS CNC Vertical Machine) Machine as per Folio FB340 Descriptions: 110 - QC2 Machining-3 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-3 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) LOCATION : LG054 140 - QC21 (QC21- Final Inspection - Work Order Release)								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
D5124-1TRN	Support	4 Ea (.5 ea)	100-HAAS 4 Axis					
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
100-HAAS 4 Axis	D5124-1TRN	4	1	0				
Part Specifications								
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments			
1	Fwd Support	2.028Inches ± 0.030	2.058 1.998					
2	Fwd Support	0.250Inches ± 0.030	0.280 0.220	Radius				
3	Fwd Support	0.188Inches + 0.005 - 0.001	0.193 0.187					
4	Fwd Support	0.257Inches + 0.006 - 0.001	0.263 0.256					
5	Fwd Support	3.150Inches ± 0.010	3.160 3.140					
6	Fwd Support	0.276Inches ± 0.010	0.286 0.266					
7	Fwd Support	0.410Inches ± 0.030	0.440 0.380					
8	Fwd Support	3.100Inches ± 0.010	3.110 3.090					
9	Fwd Support	1.472Inches ± 0.010	1.482 1.462					
10	Fwd Support	2.796Inches ± 0.010	2.806 2.786					
11	Fwd Support	0.230Inches ± 0.030	0.260 0.200					
12	Fwd Support	1.109Inches ± 0.010	1.119 1.099					
13	Fwd Support	0.250Inches ± 0.030	0.280 0.220	Radius				

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D5124-1**Job Sheet 187578****Part No:** D5124-1**Job Qty:** 8 ea**Part Name:** Fwd Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/7/18**Job Tracking No:****Due Date:** 1/18/19**Created By:** Jesse White**Type:** Stock**Description:****Note:** DWG REV B IPP rev A RQ verified by JLM 14/08/08**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Machining-3		
100	CNC Vertical Machining	8 pcs	1/18/19	1/18/19	0.37	12.31	HAAS1-4		
110	QC	8 pcs	1/18/19	1/18/19	0.00	0.00	QC2 Machining-3		
120	QC	8 pcs	1/18/19	1/18/19	0.00	0.00	QC8 Machining-3		
130	Packaging	8 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3-2		
140	QC21-SA	8 Ea	1/18/19	1/18/19	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FB340
Descriptions: 130 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5124-1TRN	Support	4 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5124-1TRN	4	1	0

H4

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Support	2.028Inches ± 0.030	2.058 1.998		
2	Fwd Support	0.250Inches ± 0.030	0.280 0.220	Radius	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

